

Work Order ID 151643

Wednesday, October 05, 2016 3:08:39 PM

Page 1

Item ID: 646.3714

Revision ID:

Item Name: Gusset

Start Date: 9/30/2016 Start Qty: 12.00

Required Date: 10/19/2016 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

646.3700

A

110

0.00

110

Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.06

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Quality Control

Memo

0.02

646.3714
B 151643
REV. A

Accept

151643***N900040100***

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

21
9-89

OCT 06 2016

PR 10/10/07

12

PR 10/10/07

Work Order ID 151643

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151643

Page 2

Item ID: 646.3714 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04				(12)			DAS 38 9-89 OCT 11 2016
140 *140* Brake NC Brake NC	Bend as per dwg Memo	0.02 0.10				DAS 30 9-89 12			OCT 11 2016
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				(12)			DAS 38 9-89 OCT 11 2016

Work Order ID 151643

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Page 3

Item ID: 646.3714 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Outsource4 Outsource process - Anodize	Outsource process-Anodize per QSI017 4.1.10.1 Memo Issue P/O to ATG : <u>34063</u> 1- Black Anodize as per Dwg 646.3700 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Comformity is required	0.00 359.99				<u>R</u>	OCT 26 2016		DAS 13 9-89
170 *170* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo	0.00 0.04				<u>dv</u>	NOV 11 2016		DAS 26 9-89
180 *180* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.04				<u>12</u>			DAS 38 9-89 NOV 11 2016

Work Order ID 151643

Wednesday, October 05, 2016 3:08:39 PM

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Page 4

Item ID: 646.3714 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gusset
Start Date: 9/30/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>CCT405</u>	0.00							
210									
Packaging	Memo	0.02							
Packaging	***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***								
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.20							
Quality Control									

12 NOV 14 2016 DAS 6 9-89

DAS 21 9-89 NOV 15 2016

DAS 21 9-89 NOV 14 2016

Picklist Print

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Page 1

Work Order ID: 151643

151643

Parent Item: 646.3714

646 3714

Parent Item Name: Gusset

Start Date: 9/30/2016

Required Date: 10/19/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 12.10.22 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			110	sf	222.1000	0.265	3.347369			

M6061T6S 063

6061-T6 .063 Sheet

DR 16/10/07

Location

Loc Qty

Loc Code

MAT021

222.1

M133511

2.6

M134377

3.3

M134830

216.2

4.1

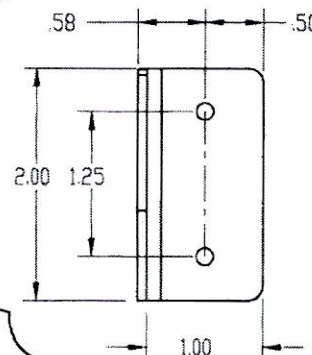
APICAL INDUSTRIES, INC.	ENGINEERING CHANGE NOTICE NO. 03702				SHEET 1 OF 2	
	DWG NO. 646.3700	REV: A	PREPARED BY B. PETERS	DATE: 11/15/12	EFFECT ON DWG ☐ INC. ☒ UNINC.	
	DWG TITLE: SHEETMETAL					
	APPROVED BY: ENGR <i>[Signature]</i>	MFG <i>[Signature]</i>	QC <i>[Signature]</i>	EFF: NEXT ORDER		
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: ADDED ALTERNATE MATERIAL AND REVISED REFERENCE DIMENSIONS				EOR: D-12-010	

SHEET 1, ZONE A2 IS:

IS

⚠ PRIMARY MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
ALTERNATE MATERIAL: SS 17-4 PH PER AMS 5604

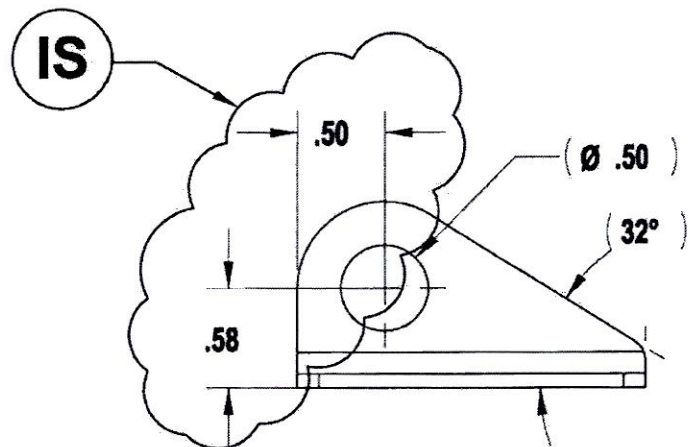
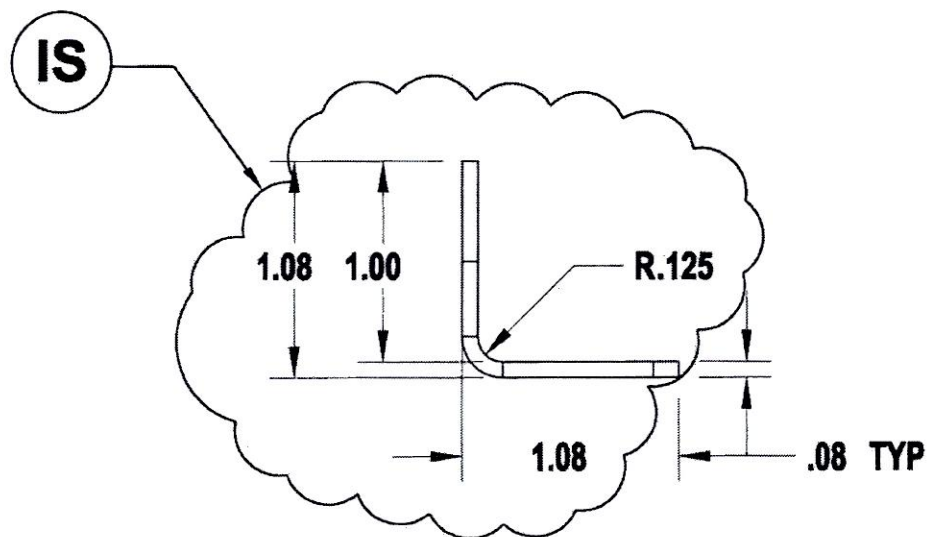
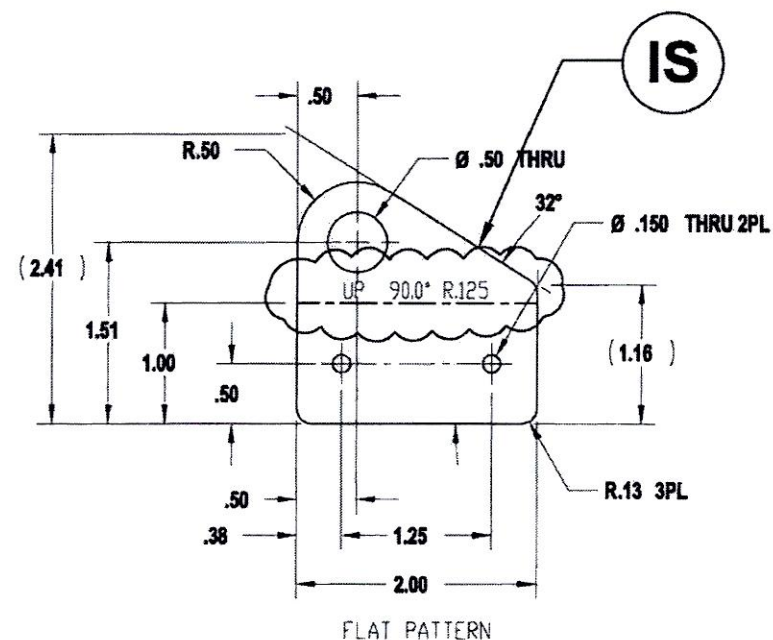
IS



SHEET 7, ZONE B1 IS:

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151642MLS
/6-10-06

F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL	SPECIFICATION
DOCUMENTS EFFECTED:				☐ RFMS ☐ MDL ☐ INSTALL INSTRU ☐ ICA ☐ BOM	CHANGE CATEGORY ☐ MAJOR ☒ MINOR	DER REVIEW REQUIRED ☐ YES ☒ NO

**SHEET 7, ZONE C4 IS:****SHEET 7, ZONE D1 IS:****SHEET 7, ZONE B7 IS:**

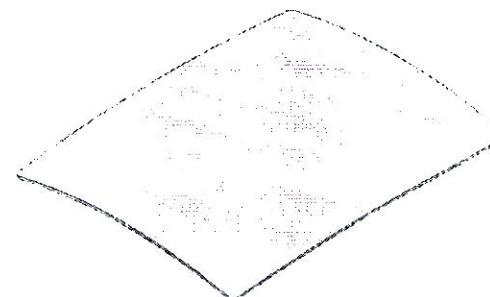
F/N	TC	PART NUMBER	QTY	DESCRIPTION	MATERIAL/SPECIFICATION
-----	----	-------------	-----	-------------	------------------------

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REV.	DESCRIPTION	DATE	APPROVED
A	UNINCORPORATED ECN 02198	01/03/08	REC'D

NOTES:

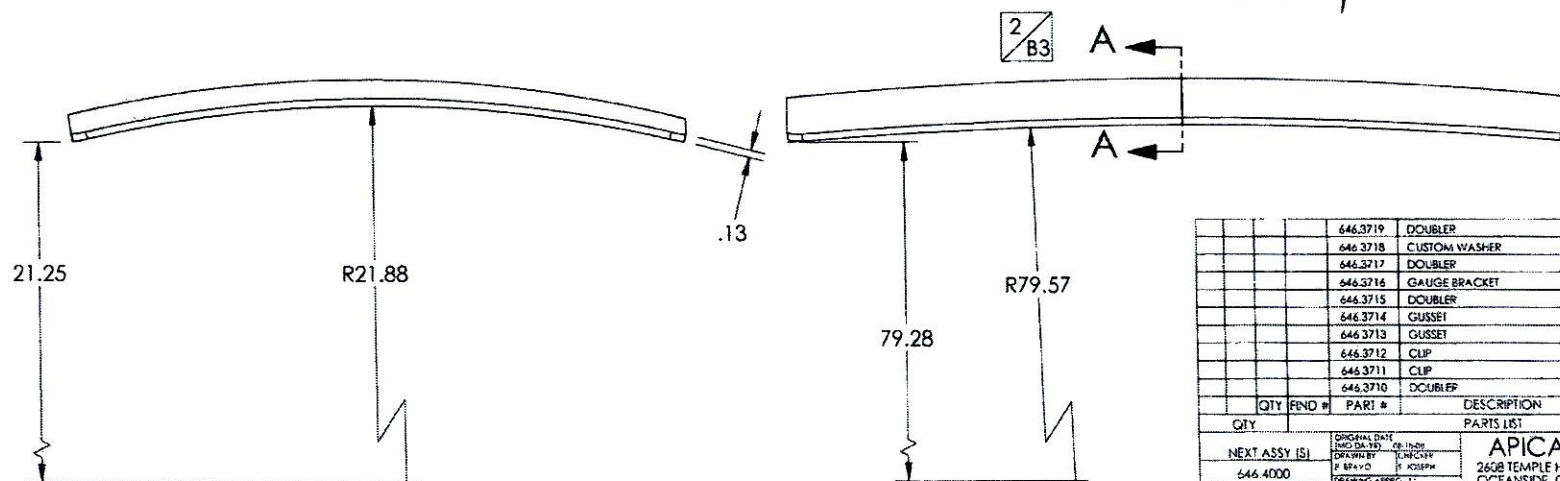
- 1 MATERIAL: ALUMINUM 6061-T6 PER AMS-QQ-A-250/11
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; CARDINAL 4860-50 PRETREATMENT PRIMER PRIME IAW MIL-P-23377J TYPE I CLASS N
- 3 MATERIAL: 17-4 PH AMS 5604, CONDITION H900
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120



646.3710

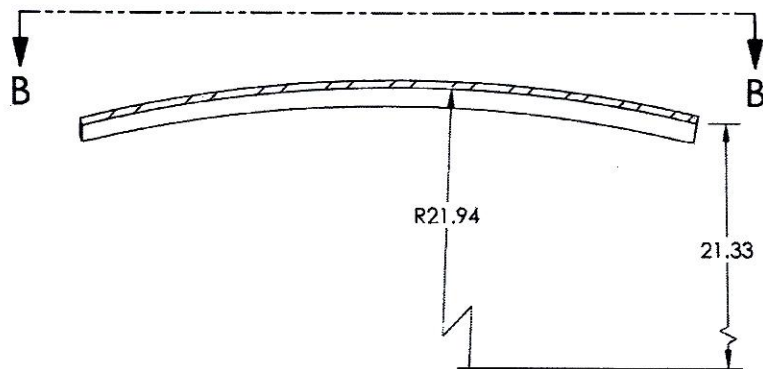
UNINCORPORATED ECN(s)

03702

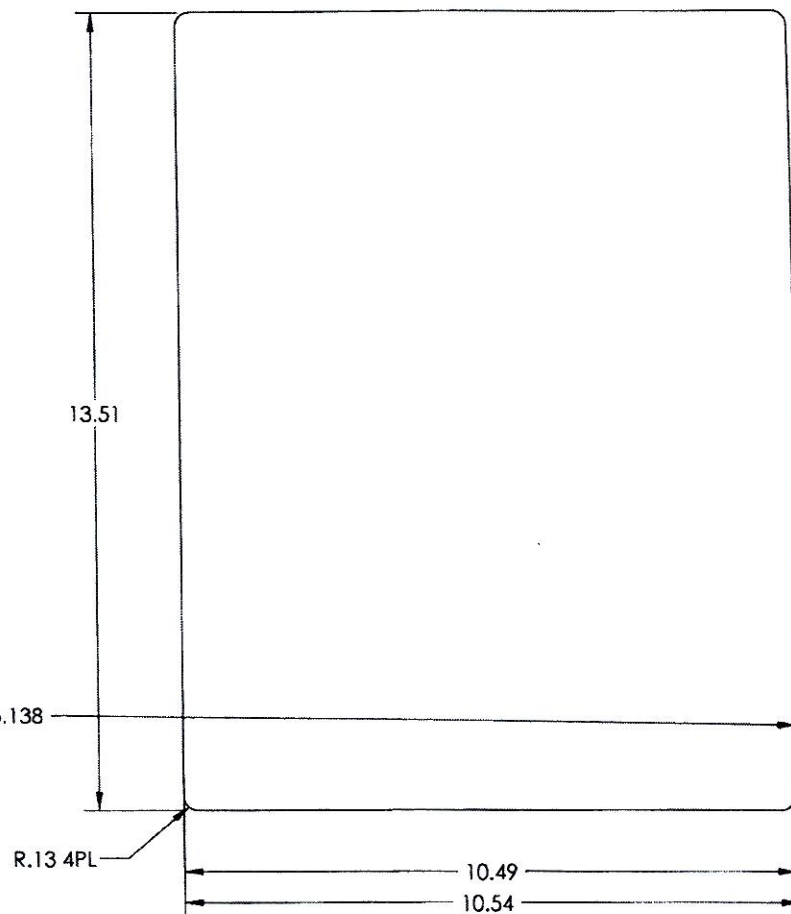


		646.3719	DOUBLER		↑	↑
		646.3718	CUSTOM WASHER		↑	↑
		646.3717	DOUBLER		↑	↑
		646.3716	GAUGE BRACKET		↑	↑
		646.3715	DOUBLER		↑	↑
		646.3714	GUSSET		↑	↑
		646.3713	GUSSET		↑	↑
		646.3712	CLIP		↑	↑
		646.3711	CLIP		↑	↑
		646.3710	DOUBLER		↑	↑
	QTY	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY				PARTS LIST		
NEXT ASSY IS:				APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE CA 92056-3512 (760)724-5300		
646.4000						
ORIGINAL DATE						
REV. DATE						
DRAWN BY				SHEETMETAL		
CHECKED						
APPROVED						
DATE						
UNLESS OTHERWISE SPECIFIED				FIN. CHAM. CODE DWG. NO. REV. A		
DIMENSIONS ARE IN INCHES						
TOLERANCES ARE:				SCALE: NONE 1 SHEET 1 OF 9		
1 PLACE DECIMALS & 01						

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SECTION A-A

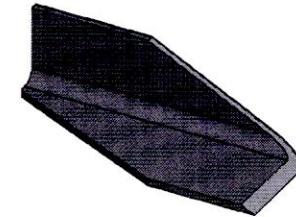
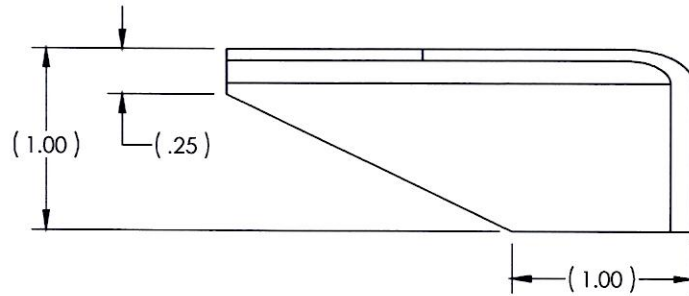


SECTION B-B

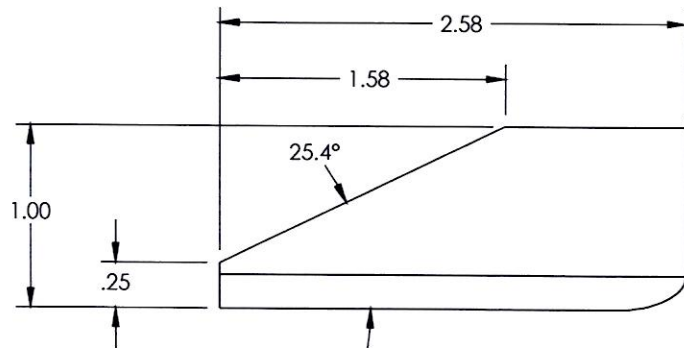
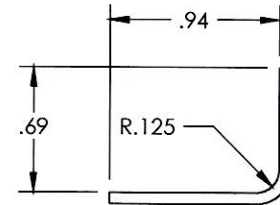
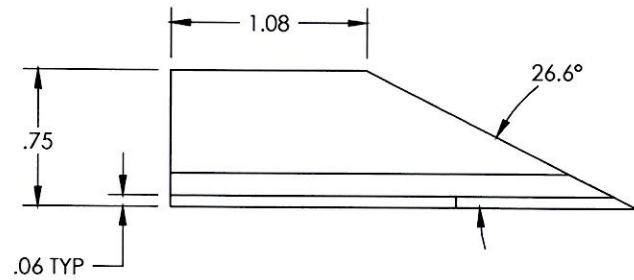
ORIGINAL DATE (MFG DATE) 08-18-08 DRAWN BY: P. MAYO CHECKED: D. JOSEPH DRAFTER APPROVAL: D. JOSEPH 08-18-08 CONTRACT NO.		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SHEET CODE B	DWG NO. 646.3700
SCALE NONE		REV A	SHEET 2 OF 3

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REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED



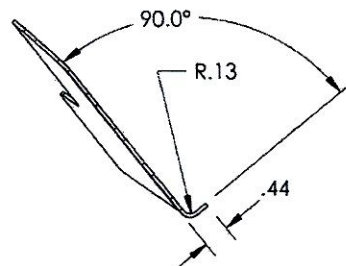
646.3711 SHOWN
646.3712 OPPOSITE



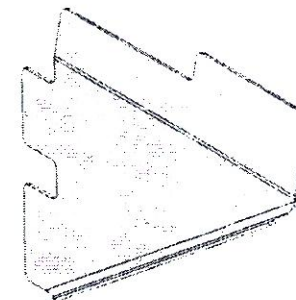
NEXT ASSY (\$)	ORIGINAL DATE 08-18-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY P. BRAVO		
	CHECKED BY S. JOSEPH		
	DRAWING APPROVAL 08-18-08		
CONTRACT NO.		SHEETMETAL	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.001 ANGLES ±.5°		SIZE B	CAGE CODE 07M26 DWG. NO. 646.3700 SCALE: NONE
		REV. A	SHEET 3 OF 9

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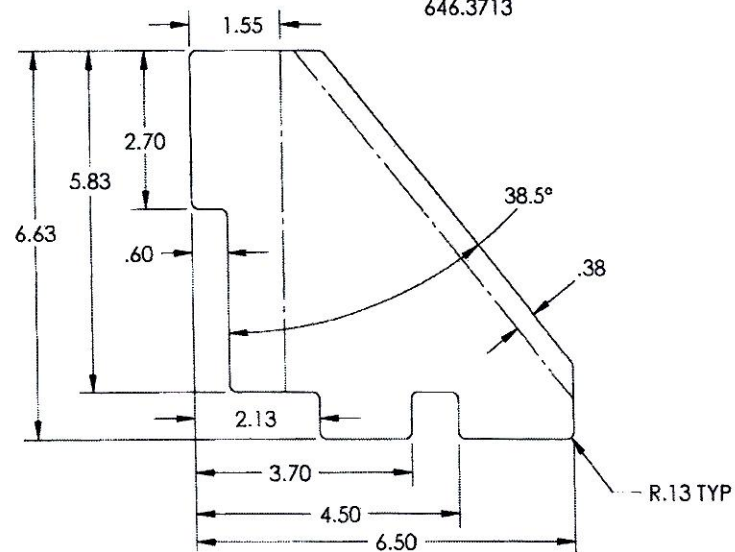
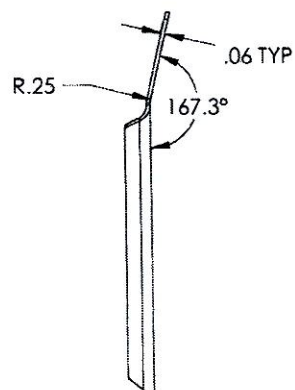
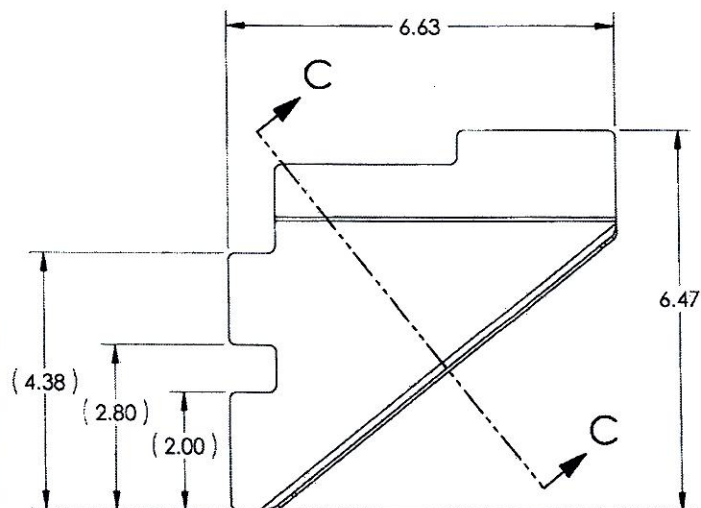
REVISIONS			
REV	DESCRIPTION	DATE	APPROVED



SECTION C-C



646.3713

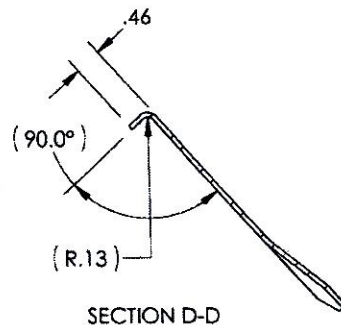
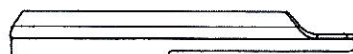


FLAT PATTERN

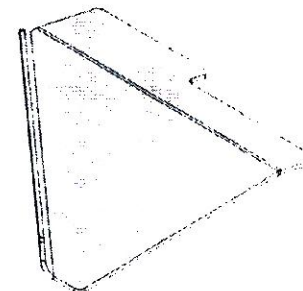
NEXT ASSY IS:	ORIGINAL DATE	08-10-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL	
	DESIGNED BY	ENGINEER		
	DRAWING APPROVAL	DATE		
	CONTRACT NO.			
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMALS PLUS MINUS			REV	A
SCALE			SHEET 4 OF 9	

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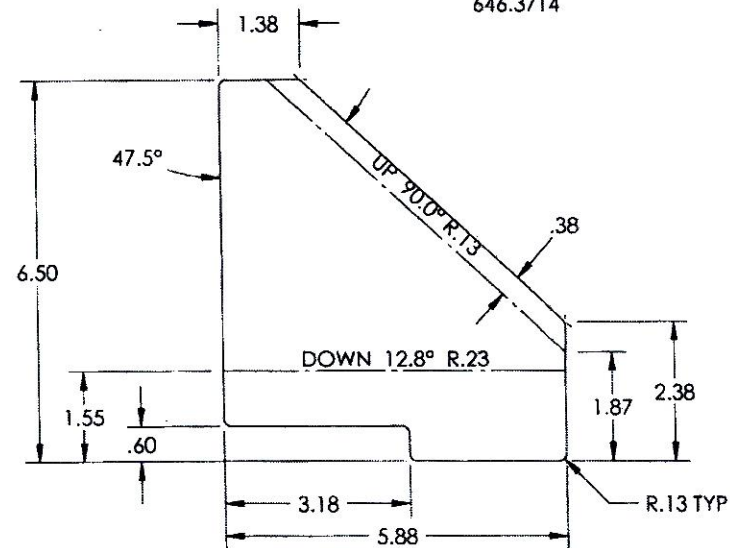
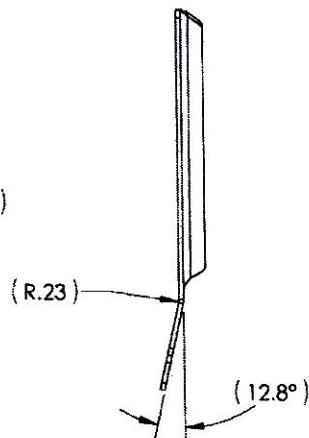
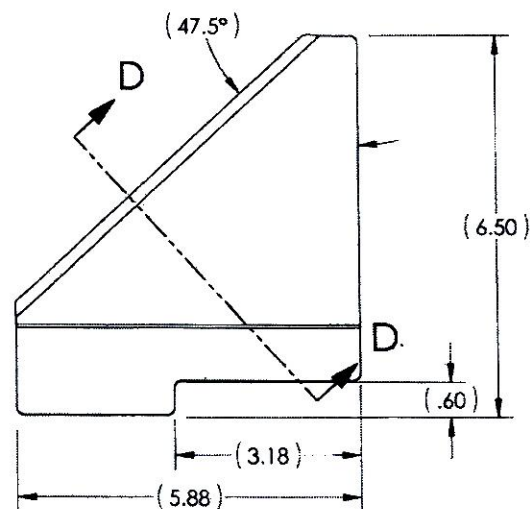
REV	DESCRIPTION	DATE	APPROVED



SECTION D-D



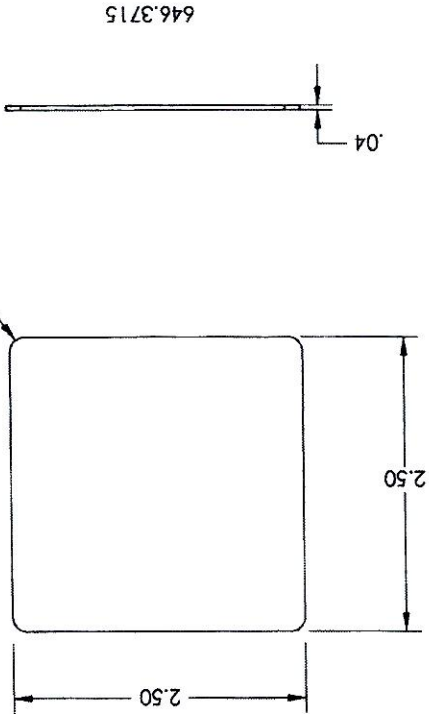
646.3714



FLAT PATTERN

ORIGINAL DATE 1/20/2015 DRAWN BY P. MAURO CHECKED BY S. JOHNSON DRAWING APPROVAL S. JOHNSON C. CORREIA	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR OCEANSIDE, CA. 92056-3512 (760)724-5300 SHEETMETAL DWG NO. 646.3700 SCALE NONE	SHEET 5 OF 9
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R.13 4PL

646.3715

.04

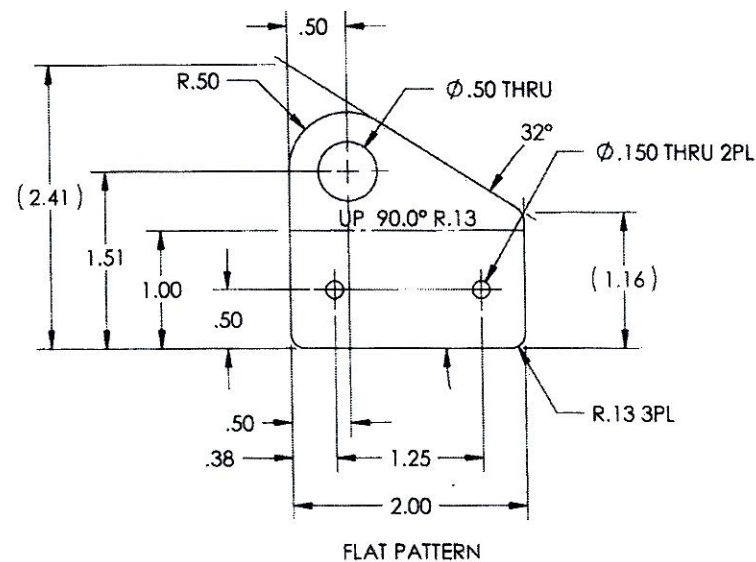
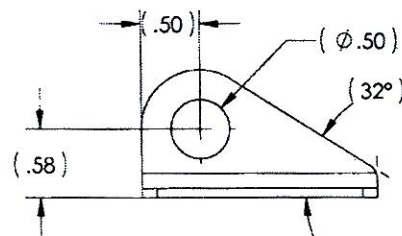
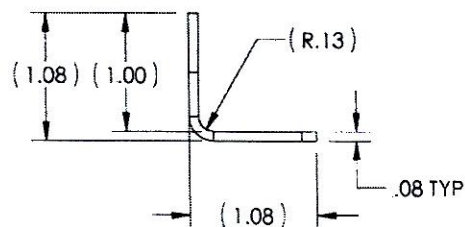
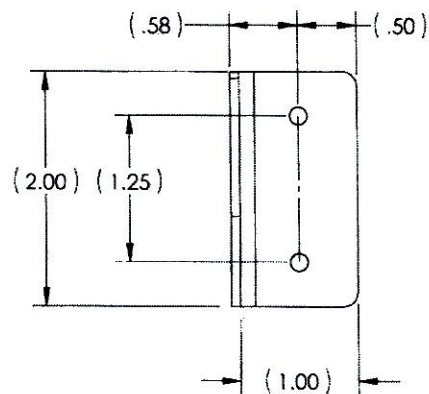
REVISION
DATE
APPROVED

SHEET ASSY (S)	
DATE: 06/18/08	DESIGNED BY: J. J. J.
DRAWN BY: J. J. J.	REVIEWED BY: J. J. J.
APPROVED BY: J. J. J.	DATE: 06/18/08
2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-5512 17601724-5300	
APICAL INDUSTRIES	
SHEETMETAL	
REV: A	646.3700
DATE: 07/24/08	SCALE: NONE
1 PLACE DIMENSIONS IN INCHES 2 PLACE DIMENSIONS IN FEET 3 PLACE DIMENSIONS IN METERS 4 PLACE DIMENSIONS IN MILLIMETERS 5 PLACE DIMENSIONS IN CENTIMETERS 6 PLACE DIMENSIONS IN KILOMETERS 7 PLACE DIMENSIONS IN MILES 8 PLACE DIMENSIONS IN KILOMETERS 9 PLACE DIMENSIONS IN MILES 10 PLACE DIMENSIONS IN KILOMETERS 11 PLACE DIMENSIONS IN MILES 12 PLACE DIMENSIONS IN KILOMETERS	

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

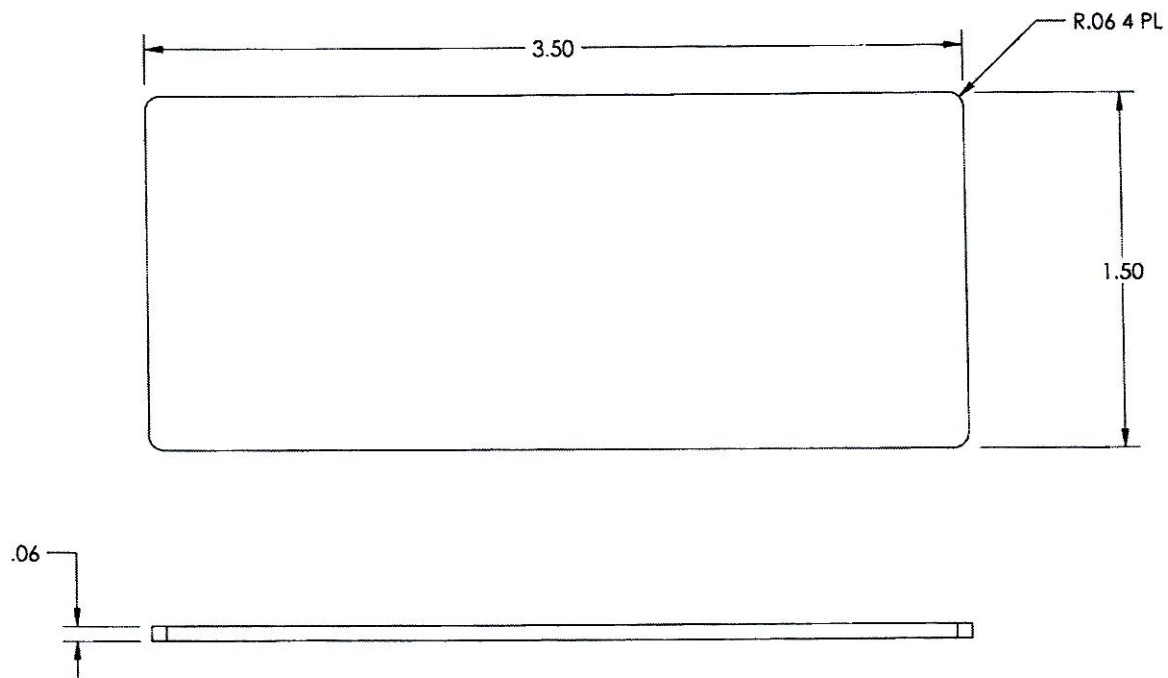
646.3716



NEXT ASSY IS:	ORIGINAL DATE	QTY SHOWN	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DATE	QTY		
			SHEETMETAL	
			DATE CODE	REV
			B 07/2016	646.3700
			SCALE	INCHES
				SHEET 1 OF 2

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REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

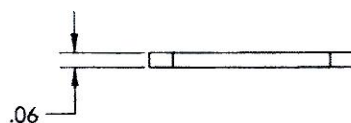
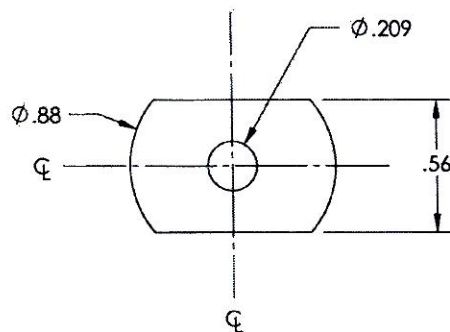


646.3717

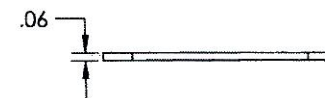
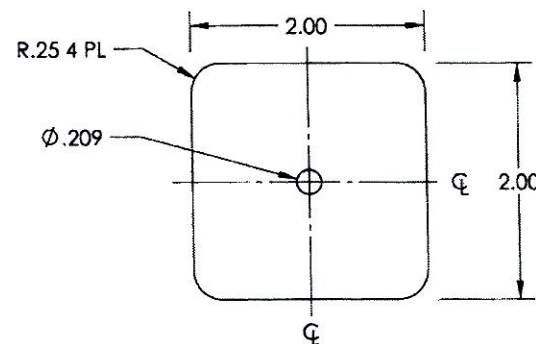
NEXT ASSY (5)	ORIGINAL DATE 08-18-82	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760)724-3300
	DRAFTER BY J. BRAYNO CHECKED BY J. JOHNSON DESIGNED APPROVAL J. JOHNSON SCALE CONTRACT NO.	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 1 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°		SEE SCALE CODE DWG. NO. 646.3700
SCALE 1"=4'-0"		SHEET 8 OF 9

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REVIEWS			
REV.	DESCRIPTION	DATE	APPROVED



646.3718



646.3719

NEXT ASSY IS:	ORIGINAL DATE	09-16-08	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
	DRAWN BY	J. KETTER		
	P. BRAVO	S. JOSEPH		
	DRAWING APPROVAL	S. JOSEPH		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 2 PLACE DECIMALS ±.005 ANGLES ±.5°	DATE	09-16-08	SHEETMETAL SET / LAST CODE DWT. NO. 646.3700 8 07M26	
	SCALE	1:1000		
	SHEET	5 OF 5		
	DATE	09-16-08		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

Purchase Order ID PO34063

Purchase Order Date 10/26/2016
PO Print Date 10/27/2016

Page Number 4 of 9

VC-ATG001

Order From:

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To: DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 613-446-4544

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA - (Free Carrier)

Line Total: \$67.10

9 151646

646.3713 GUSSET REV. A 11/9/2016
Yes
11/9/2016

12.00

\$65.75 \$189.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS 1

10

151643

DAS
38
9-89

646.3714 GUSSET REV. A 11/9/2016
Yes
11/9/2016

12.00

DAS
26
9-89

\$15.75 \$189.00

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Line Total: \$189.00

11 151477

646.3810 BRACKET
REV. N/C

11/9/2016
Yes
11/9/2016

10.00

\$6.55 \$65.50

FINISH: HARD BLACK ANODIZE AS PER IAW MIL-A-8625 TYPE III, CLASS 2 / PRIME AS PER IAW MIL-P-23377J TYPE I CLASS N

Note:

10/27/2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

CHANTAL LAVOIE
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	PLEASE REFERENCE THE PACK LIST NUMBER ON ALL CORRESPONDENCE TO THIS SHIPMENT. IF YOU HAVE ANY QUESTIONS, PLEASE CALL AT (613) 446-4544.		
12 ea	Part: 646.3714 Gusset Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20317	Rev: A DAS 26 9-89 DAS 38 9-89	Line: 10 NOV 11 2016
10 ea	Part: 646.3810 Bracket Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20318	Rev: N/C PO: 34063	Line: 11
10 ea	Part: 646.3811 Radius Block Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20319	Rev: N/C PO: 34063	Line: 12
10 ea	Part: 646.9710 Body Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20320	Rev: D PO: 34063	Line: 13
6 ea	Part: 647.0113 Strut Doubler Hard Anodize, Type III, Class 2 (MIL-A-8625) Primer, MIL-P-23377J, TYPE 1, CLASS N Job: 20321	Rev: A PO: 34063	Line: 14
8	Part: 647.0210	Rev: N/C	

NOV 11 2016



A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE STREET
ROCKLAND, ON K4K 1T2
Canada

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Fax: (613) 446-4556

Pack List

Number: 912522

Date: 09-Nov-16

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1270 Aberdeen St
Hawkesbury, ON K6A 1K7

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Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms	Ship Via
Quantity	Description
	DATE : <u>9/11/16</u>
	CERTIFIED SIGNATURE : <u>DAS</u>
	RECEIVER SIGNATURE : <u>26 NOV 11 2016</u>
	<u>9-89</u>
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.
	CERTIFICATE OF CONFORMANCE
	A.T.G. INDUSTRIES INC. CERTIFIES THAT ALL ITEMS IN THIS SHIPMENT CONFORM TO REQUIREMENTS.
	MADE IN CANADA.
	<u>DAS</u>
	<u>38</u>
	<u>3-89</u>